

Work Order ID 73038

Wednesday, August 24, 2011 2:24:44 PM



Page 1

Item ID: D3512-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 8/24/2011 Start Qty: 12.00

Required Date: 8/31/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3512

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3512 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-  
Deburr if necessary

304, 063

B11-8-29

12

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-29

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 uloe/30

912

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr if necessary ☐ Form as per dwg D3512 using DT8179

0.00

0.00

SB 11/09/07

12

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 11/09/07

12

150



Large Fab

Large Fab

Large Fab

Memo

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004 ☐ Qty  
Description Batch ☐ A/R 2059b Hardcoat Rod

0.00

0.00

M118453

X2 11-09-07 JBL



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73038

Wednesday, August 24, 2011 2:24:44 PM



Page 3

Item ID: D3512-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 8/24/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 8/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

*S. L. L. L. L.*



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

2:15  
FINISH TIME:

OVEN TEMPERATURE:

320°F

2:45

*2x ✓ m-11/09/07*

*M117338*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 73038

Wednesday, August 24, 2011 2:24:44 PM



Item ID: D3512-1	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Wearplate				
Start Date: 8/24/2011	Start Qty: 12.00		Cust Item ID:	
Required Date: 8/31/2011	Req'd Qty: 12.00		Customer:	
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				2	0	11/09/07	
200  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00  0.00							
210  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

*SL*

*(2x)*

*11-09-07*

*11/9/07*

*MF 11-09-07*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, August 24, 2011 2:24:53 PM

Page 1

Work Order ID: 73038



Parent Item: D3512-1



Parent Item Name: Wearplate

Start Date: 8/24/2011

Required Date: 8/31/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-06-20 JLM  
IPP Rev:B Now SS as per Rev B 06-12-15 JLM  
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

203.6000

0.261

3.296842



B11-8-X

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

120

118578

120

MAT021

83.6

118217

83.6

118578

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

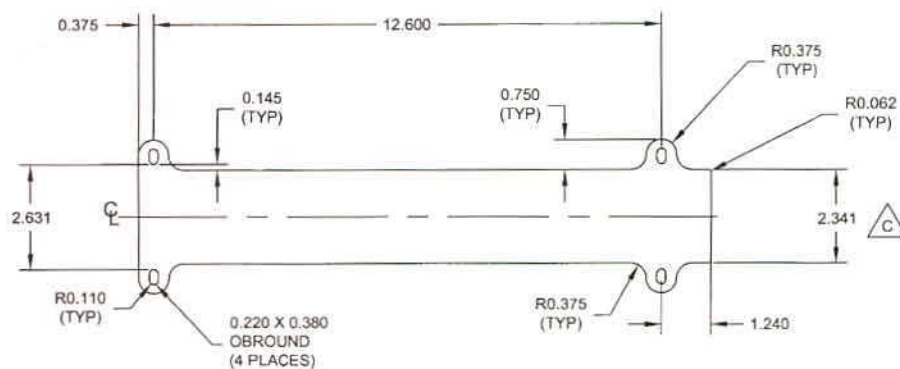
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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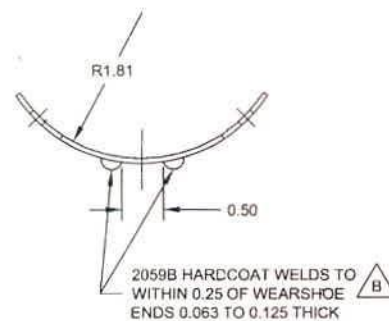




**D3512-1F FLAT PATTERN**



**D3512-1 BENDING DETAIL**



**SECTION A-A  
SCALE 2:3**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 73038

RELEASED  
07.11.16 1/16



**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

C	ENLARGE OBOURD FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA

DRAWING NO. D3512  
TITLE WEARPLATE  
REV. C  
SHEET 1 OF 1  
SCALE 1:3

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